

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014834**Date Inspected:** 03-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Li Yang and Wu Zhi Cheng	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG Trial Assembly	

**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 9AE to 9BE (Longitudinal Diaphragm) Joint Survey

This QA Inspector performed Joint Inspection with ZPMC Survey Team and ABF Survey Team for the Longitudinal Diaphragm between Segment 9AE to 9BE (Shop Segment Splice) between Panel Point (PP) 73 and PP 74 North(Cross Beam side) and South (Bike Path side) for Offset and Sweep. The offset was measured at 5 (five) different locations in which 2 (Two) locations were at Flange area and 3 (Three) locations were at Web area and Sweep was measured at 100 mm from both side from the Floor Beam and 800mm from both side of floor Beam and at Centre (Total 5 Locations). The measured readings were recorded on spread sheet and submitted to the Lead and Engineer for review.

Segment 8AE, 8BE and 8CE (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 61 to PP

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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70 Bike Path Side. The measured readings were recorded on spread sheet and submitted to the Lead and Engineer for review.

Segment 8AE, 8BE and 8CE (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 61 to PP 70 Cross Beam Side. The measured readings were recorded on spread sheet and submitted to the Lead and Engineer for review.

Segment 7AE, 7BE, 7CE, 7DE and 7EE (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 48 to PP 60 Bike Path Side. The measured readings were recorded on spread sheet and submitted to the Lead and Engineer for review.

Segment 7AE, 7BE, 7CE, 7DE and 7EE (Side Panel to Corner Assembly)

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector Mr. Manoj Prabhune for the Side Panel to Corner Assembly Longitudinal Weld Skin Flatness from Panel Point (PP) 48 to PP 60 Cross Beam Side. The measured readings were recorded on spread sheet and submitted to the Lead and Engineer for review.

Segment 8BW to 8CW (U-Ribs)

This QA Inspector generated Dimension Control Report for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8BW to 8CW (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 from North side towards South side. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8CW to 9AW (U-Ribs)

This QA Inspector generated Dimension Control Report for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8CW to 9AW (Field Segment Splice) between Panel Point (PP) 71 and PP 72 from North side towards South side. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Segment 8BW to 8CW (U-Ribs)

This QA Inspector generated Dimension Control Report for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8BW to 8CW (Shop Segment Splice) between Panel Point (PP) 67 and PP 68 from North side towards South side. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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Segment 8CE to 9AE (U-Ribs)

This QA Inspector generated Dimension Control Report for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 8CE to 9AE (Field Segment Splice) between Panel Point (PP) 71 and PP 72 from North side towards South side. The measured readings were fed in spread sheet, generated the report and submitted to the Task Leader and Engineer for review.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No relevant conversations.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath	Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer
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